

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016118**Date Inspected:** 28-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1330**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA.

CWI Name:	Rick Rodriguez		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No N/A
Weld Procedures Followed:	Yes	No N/A
Verified Joint Fit-up:	Yes	No N/A
Approved WPS:	Yes	No N/A
Delayed / Cancelled:	Yes	No N/A
Component:	Travelers	

Bridge No: 34-0006**Summary of Items Observed:**

The Quality Assurance Inspector Sean Vance arrived on site at Westmont Industries (WMI) in Santa Fe Springs, CA, to randomly observe the in process welding of the Travelers. The QA Inspector arrived on site to randomly observe the WMI Quality Control (QC) Inspectors in process and completed visual and nondestructive testing. Upon the arrival of the QA Inspector the following observations were made:

Traveler E2/E3-EB

On this date, the QA Inspector observed Westmont Industries (WMI) production personnel Mr. Tim Hartnett, cutting material for the E2/E3-EB Traveler.

The QA Inspector observed that Mr. Hartnett was utilizing a Marvel Brand 15 A series horizontal band saw, to perform the cutting operations at production station # 1 and observed that the material being cut, was identified as 3 x 3 x .1875 and 2.5 x 2.5 x .1875 rectangular tubing.

Mr. Harnett explained to the QA Inspector that he was provided a list of material to be cut to a specific length, by the WMI shop supervisor, Mr. George Grayum, per the shop drawings. Mr. Harnett explained that he was cutting the material to these specific lengths and marking the material with a white paint stick marker, to identify the individual cut pieces of material, per the shop drawing bill of material list. The QA Inspector observed that Mr. Harnett identifying the rectangular tubing as piece marks D251, A248 and C248.

The QA Inspector verified the dimensions of the rectangular tubing per the approved shop drawings and the tubing appeared to be in compliance.

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The QA Inspector observed that after the material was cut to length and identified, that the material was then transferred to another production station. Mr. Harnett explained further that at this station, the required angles will then be marked for cutting, on the end or ends of the rectangular tubing.

The QA Inspector observed that at this station, identified as station # 2, WMI production personnel Mr. Juan Mora was present and currently laying out the angles on the end of the above mentioned rectangular tubing.

The QA Inspector observed that Mr. Mora was utilizing a mechanical tri-square and white soapstone to perform this task. Mr. Mora explained to the QA Inspector that once the applicable angles were laid out per the shop drawings, that the tubing will then be transferred to a third production station, for cutting of the angles.

The QA Inspector then observed that WMI production Mr. Jose' Rodriguez was cutting these angles at production station identified as # 3 and that Mr. Rodriguez was utilizing a Hem Saw brand VT 130A-60 adjustable angle band saw, to perform this task.

The QA Inspector observed that Mr. Mora had placed a square wooded 4" x 4" wooden block on one end of the rectangular tubing to lift, so that the required angle could then be cut with the band saw. Mr. Mora explained to the QA Inspector that various sizes of wooden blocks were previously cut and will be utilized to lift the end of the rectangular tubing, depending on which cut angle is required. The QA Inspector observed that this method is efficient and effective for cutting the angles.

The QA Inspector observed that once the angles were cut on the rectangular tube, Mr. Rodriguez then placed the rectangular tube on a wooden pallet, nearby the work area.

The QA Inspector later observed that the final finished cut rectangular tubing, had been transferred to a laydown area in the production bay and strategically placed in piles, for future fit-up and tack welding, on the E2/E3-EB Traveler.

The QA Inspector also observed that the rectangular tubing, had been previously inspected by WMI QC Inspector Rick Rodriguez and that the Mill Test Report's (MTR's) had been previously provided to the QA Inspector.

The QA Inspector observed that the above mentioned material had been previously inspected by the QA Inspector and appeared to be in compliance with the contract requirements..

Material, Equipment, and Labor Tracking (MELT)

QA Inspector Sean Vance performed a verification of material, personnel and equipment involved with the project. The QA Inspector observed at Westmont Industries: 1 QC, 1 supervisor and 3 production personnel.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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Inspected By:	Vance,Sean	Quality Assurance Inspector
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Reviewed By:	Edmondson,Fred	QA Reviewer
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